

Date: Friday, 18/07/2008 1:20:03 PM
 User: Julie Lecocq

Process Sheet

| | | | |
|------------------------------------|--|---------------------------|---------------|
| Customer : | CU-DAR001 Dart Helicopters Services | Drawing Name : | TUBE ASSEMBLY |
| Job Number : | 40665 | | |
| Estimate Number : | 13287 | | |
| P.O. Number : | | Part Number : | D3697041 |
| This Issue : | 18/07/2008 | S.O. No. : | |
| Prsht Rev. : | NC | Drawing Number : | D3697 REV B |
| First Issue : | 1/1 | Project Number : | N/A |
| Previous Run : | 38871 | Drawing Revision : | B |
| Written By : | | Material : | |
| Checked & Approved By : | JUL 08.7.18 | Due Date : | 08/08/2008 |
| Comment : | Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec | | |

Qty: 2 Um: Each

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6T0375W049

6061-T6 RD Tube .375 x.049W



Comment: Qty.: 6.3000 f(s)/Unit Total : 12.6000 f(s)

6061T6 aluminium tube OD 0.375" X 0.049" wall

(M6061T6T0.375W0.049)

Batch: M107967

FF 08-08-19

(2)

2.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut at 6.00" as per dwg D3697

2- form and trim tube as per dwg D3697 using DT9003

3-deburr

FF 08-08-19

(2)

3.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/06/19 (42)

4.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 40665

Part Number: D3697041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D37971

Ground Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Ground Plate

batch: 41023

54

6.0

D36973

Support Plate, LH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Support Plate, LH

batch: B 41024

LS 08/08/27

7.0

D36974

Support Plate, RH



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

✓ Support Plate, RH

batch: B 41025

LS 08/08/27

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

- ✓ 1-weld D3697-3/-4 and D3797-1 on tube D3697-1 as per dwg D3697 using DT9003 welding jig
- ✓ 2-drill holes in tube in 5 pls as per dwg D3697

LS 08/08/27 (2)

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

LS 08-08-28 (2)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

LS 08/08/28 (2)

11.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Chemical Conversion Coat as per QSI 005 4.1

2- Mask hatched areas (5 pls) on both sides of ground plate only. Before powder coating.

LS 08/08/27 (X2)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 40665

Part Number: D3697041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

POWDER COATING

POWDER COATING



M102316



(2x)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

9:00
320°F
9:30

M. 08/08/28

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



M



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08-08-28 x 2

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

G.A.

FF 08/08/28

(2)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



(2)

Comment: FINAL INSPECTION/W/O RELEASE

08/08/29

Job Completion



U 08.08.28

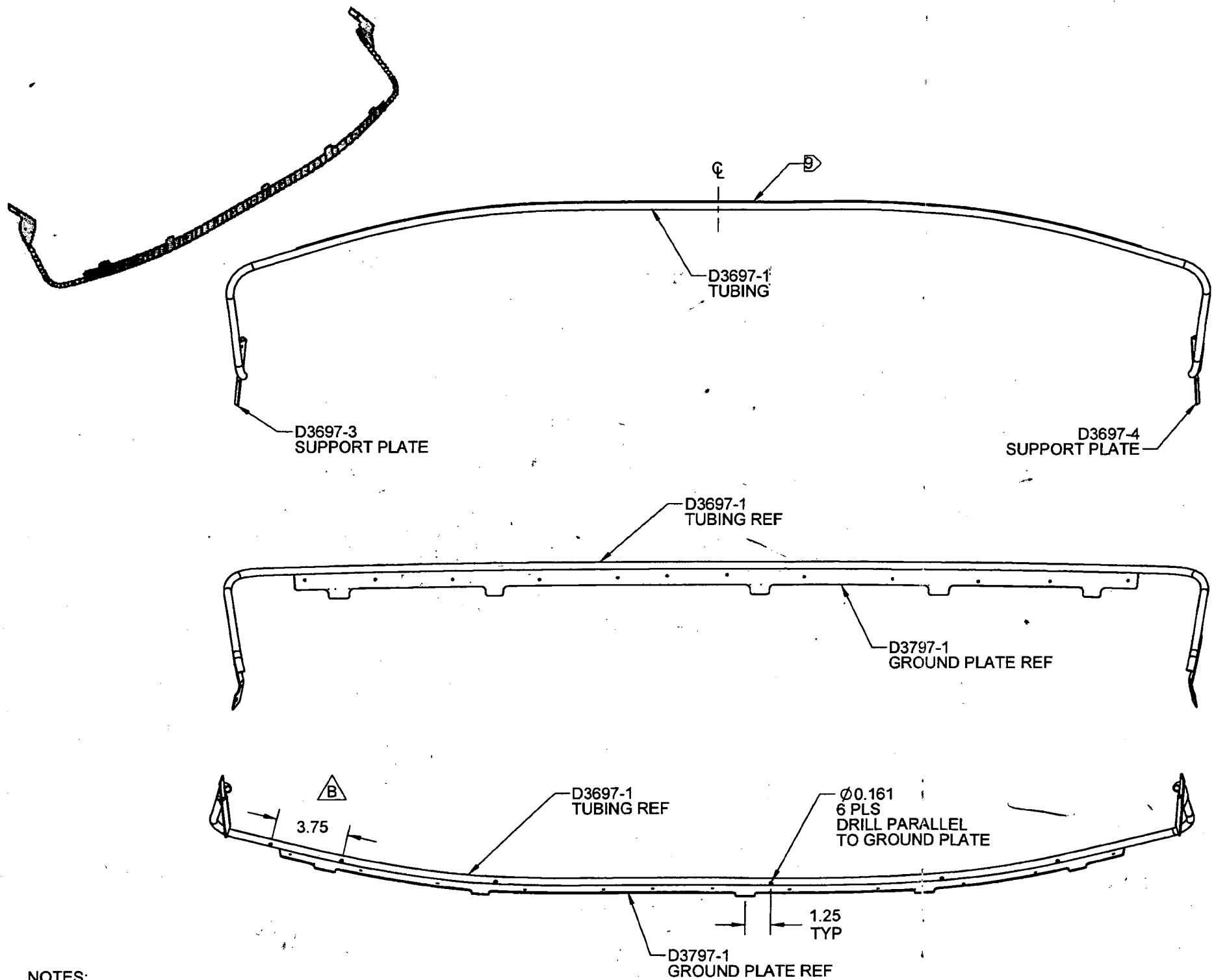
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

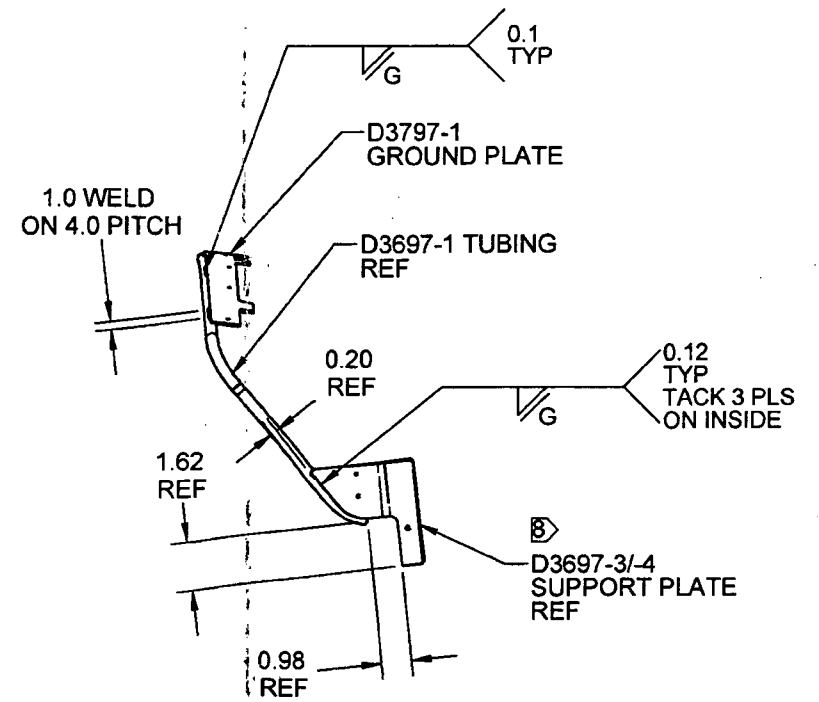
| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries



- NOTES:
- 1) WELD PER QSI 004
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.55 lbs
 - 8) LOCATE D3697-3/-4 ON D3697-1 USING DT9009 WELDING JIG
 - 9) CENTER D3797-1 GROUND PLATE ON D3697-1 TUBING

D3697-041.TUBE ASSEMBLY



PART LIST

| QTY -041 | PART NUMBER | DESCRIPTION |
|-------------|-------------|---------------|
| X | D3697-041 | TUBE ASSEMBLY |
| 1 | D3697-1 | TUBING |
| 1 | D3697-3 | SUPPORT PLATE |
| 1 | D3697-4 | SUPPORT PLATE |
| 1 | D3797-1 | GROUND PLATE |

| B | REMOVE POWDER COAT & MASKED HATCHED AREAS. SHEET 1 ZONE A,8; ADD Ø0.161 HOLE. SHEET 1 ZONE B,7 | RF | 08.06.02 |
|------------|--|----|----------|
| A | NEW ISSUE | RF | 08.05.26 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | RF | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 08.06.02 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3697**

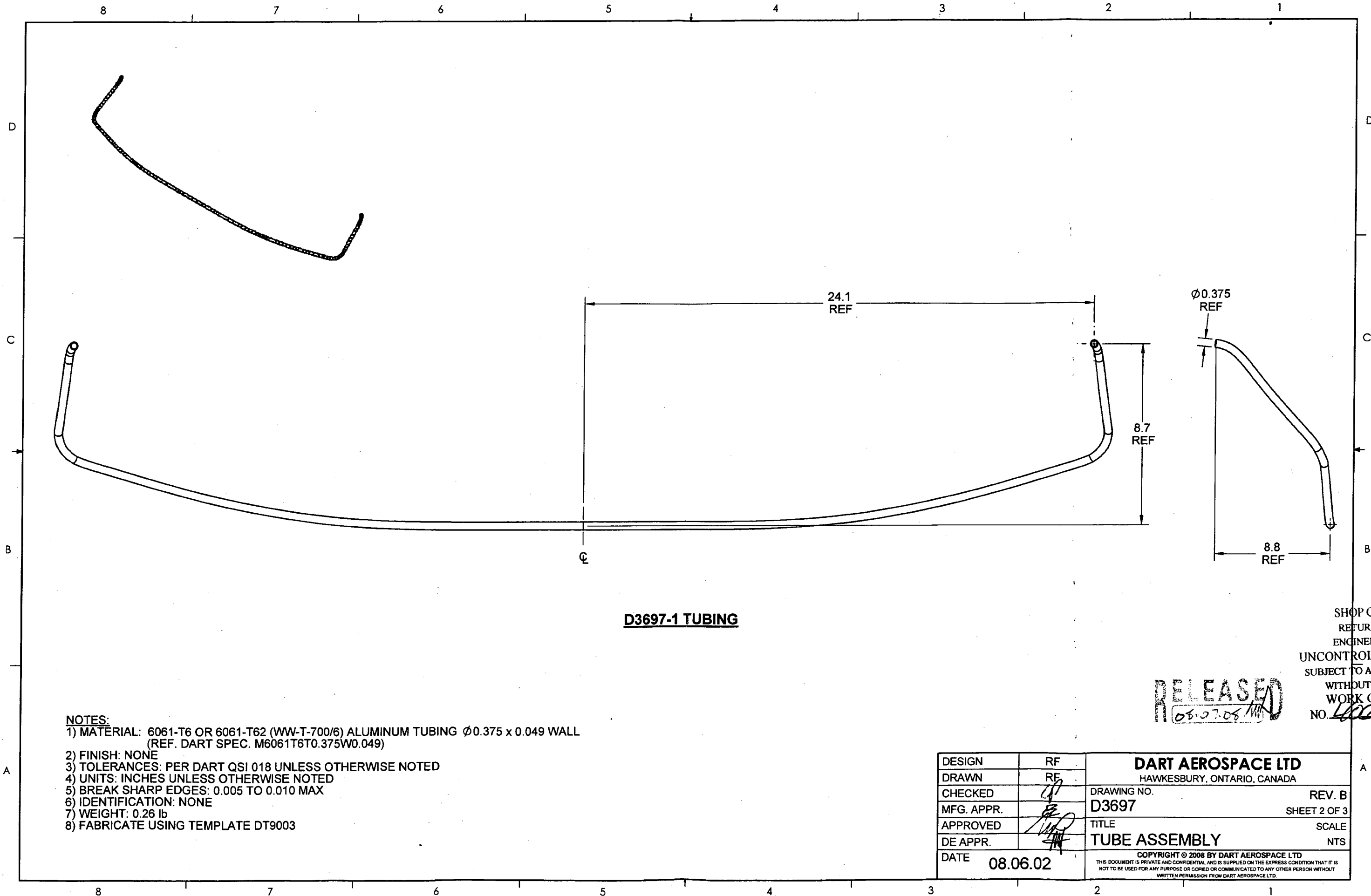
TITLE **TUBE ASSEMBLY**

REV. B
SHEET 1 OF 3

SCALE
NTS

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D3697-1 TUBING

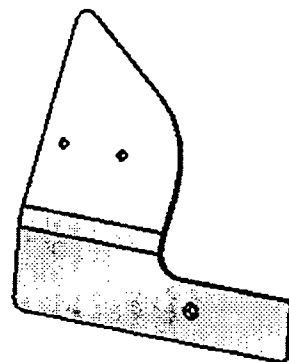
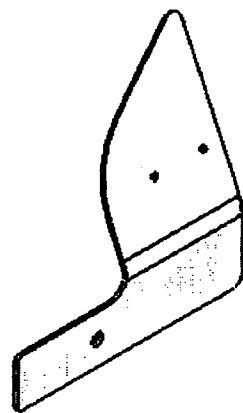
NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (WW-T-700/6) ALUMINUM TUBING Ø0.375 x 0.049 WALL (REF. DART SPEC. M6061T6T0.375W0.049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.26 lb
- 8) FABRICATE USING TEMPLATE DT9003

RELEASED
06.07.06

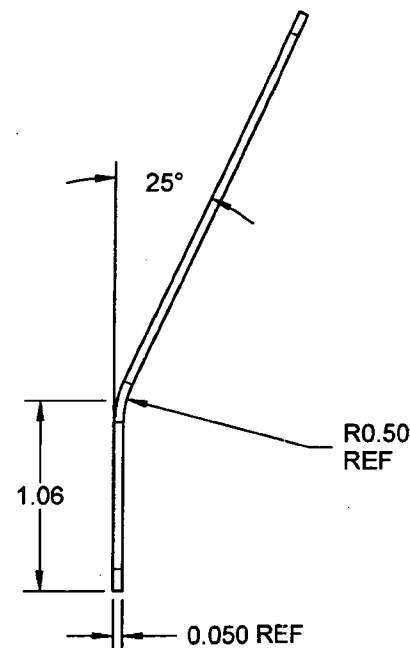
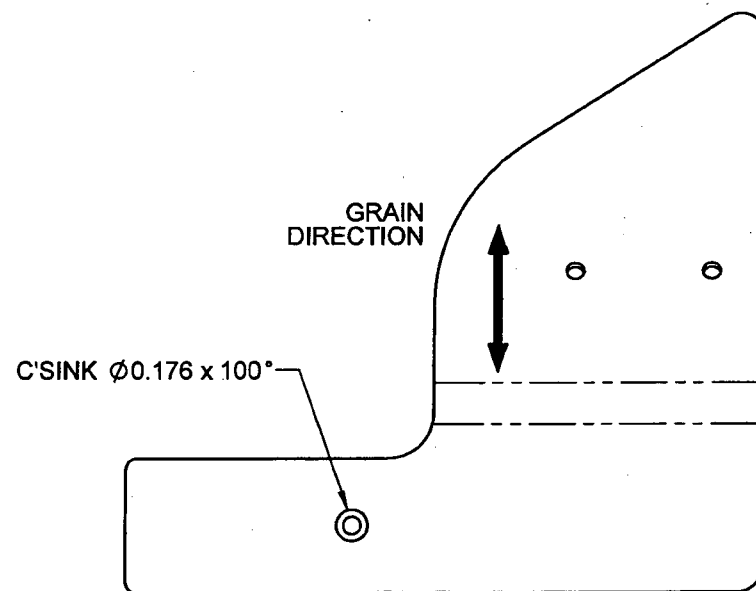
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| DRAWN | RE | | |
| CHECKED | <i>[Signature]</i> | DRAWING NO. D3697 | REV. B |
| MFG. APPR. | <i>[Signature]</i> | SHEET 2 OF 3 | |
| APPROVED | <i>[Signature]</i> | TITLE | SCALE |
| DE APPR. | <i>[Signature]</i> | TUBE ASSEMBLY | NTS |
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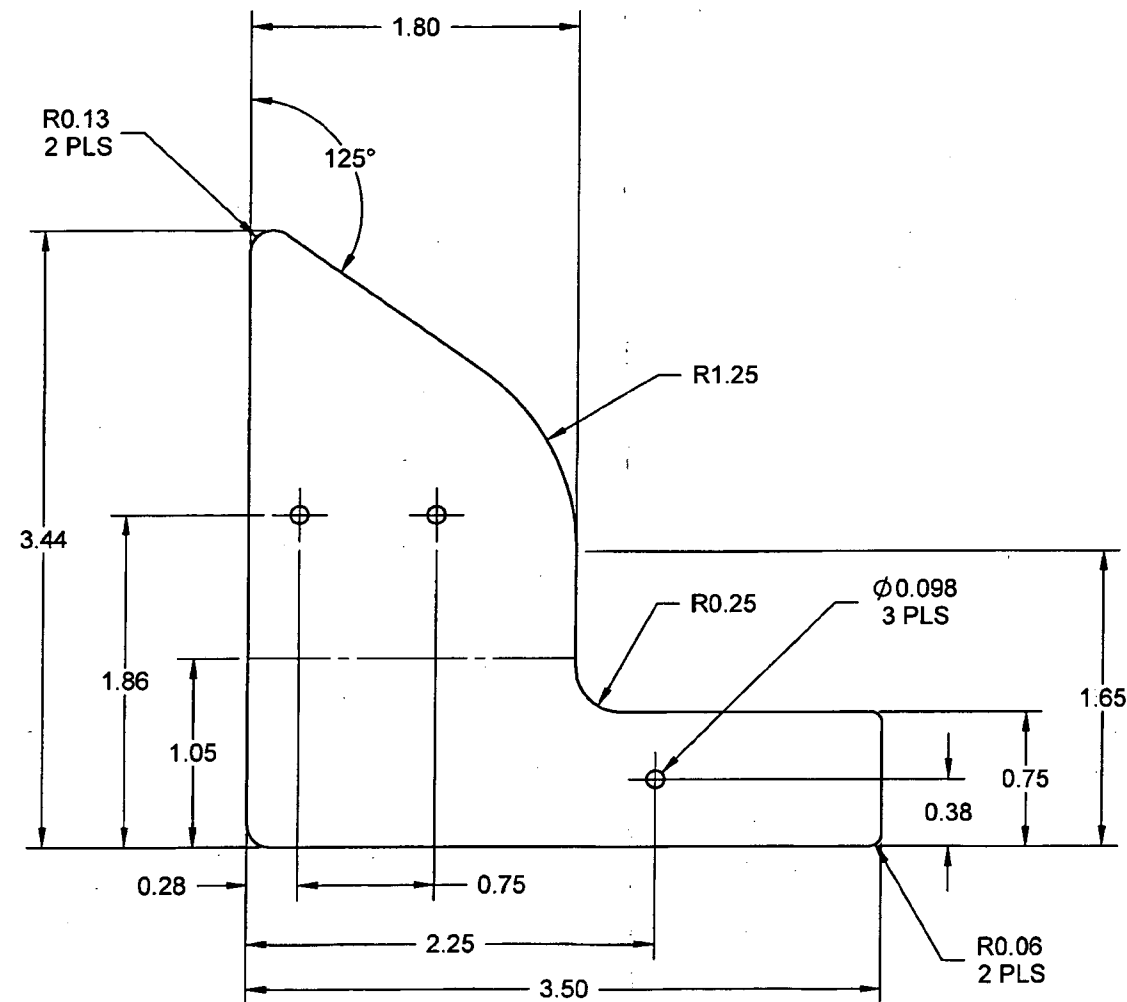


D3697-3 SUPPORT PLATE (LH SHOWN)

D3697-4 SUPPORT PLATE (RH SHOWN)



D3697-3 SUPPORT PLATE (LH SHOWN)
(D3697-4 SUPPORT PLATE OPPOSITE)
(MAKE FROM D3697-3F FLAT PATTERN)



D3697-3F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.050 THICK (REF. DART SPEC. M6061T6S.050)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.03 lbs

| | | | |
|------------|----------|---|--------------|
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| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3697 | SHEET 3 OF 3 |
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